

## ABSTRACT

This invention relates to foundry binder compositions that contain a divalent sulfur compound, and/or foundry mixes where the aggregate contains a divalent sulfur compound. The foundry binders and foundry mixes are used to make foundry shapes, 5 e.g. molds and cores. The presence of sulfur in the foundry shape facilitates the removal of foundry shapes (particularly internal cores) from the metal casting which is made by pouring molten metal into a casting assembly in which the foundry shapes are arranged. The invention also relates to a method of preparing foundry shapes, the shapes prepared, a method of making a metal casting, and metal castings by this 10 process.